

SPLIT-2

Work Order ID 92956-2

change labour to RD 4397.

\*92956\*

November 12-12 1:36:54 PM

Page 1

Item ID: D4635-2 Accept ~~\*N9000040100\*~~ Setup Start ~~\*NS1\*~~  
 Revision ID: Stop ~~\*NS2\*~~  
 Item Name: Fwd Ceiling Panel, RH  
 Start Date: 12/11/2012 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 12/12/2012 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: M L J Date: 12-11-12 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4635	AB 12/12/05

100		0.00							
*100*	HAND FINISHING THERMOFORMING					x2			DAS 07 12/12/05
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

105		0.00							
*105*	Dry Material					x2			DAS 07 12/12/05
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								

Temp: 150° F  
 Time IN: 7:00 pm 12/12/04  
 Time OUT: 7:00 am 12/12/05





Work Order ID 92956

\*92956\*

Page 3

November-12-12 1:36:54 PM

Item ID: D4635-2 Accept ~~\*N9000040100\*~~ Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd Ceiling Panel, RH  
 Start Date: 12/11/2012 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 12/12/2012 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC5- Inspect part completeness to step on W/O 0.00

\*150\*

QC

Quality Control

Memo

0.00

0.00

DAS  
16  
9-03 13/04/05

160

\*160\*

Packaging

Packaging

Packaging

Memo

MED FAB.  
B 98237

0.00

0.00

DL  
13/04/10

170

\*170\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

13/04/10

B-04-10

# Picklist Print

November-12-12 1:36:57 PM

Page 1

Work Order ID: 92956

\*92956\*

Parent Item: D4635-2

\*D4635-2\*

Parent Item Name: Fwd Ceiling Panel, RH

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,028.362	13.36	29.68889			

\*MKYD6185S 080-P3-62015\*

6185 KYDEX .080"

\*\*

Location

Loc Qty

Loc Code

therm

1028.362377

116576

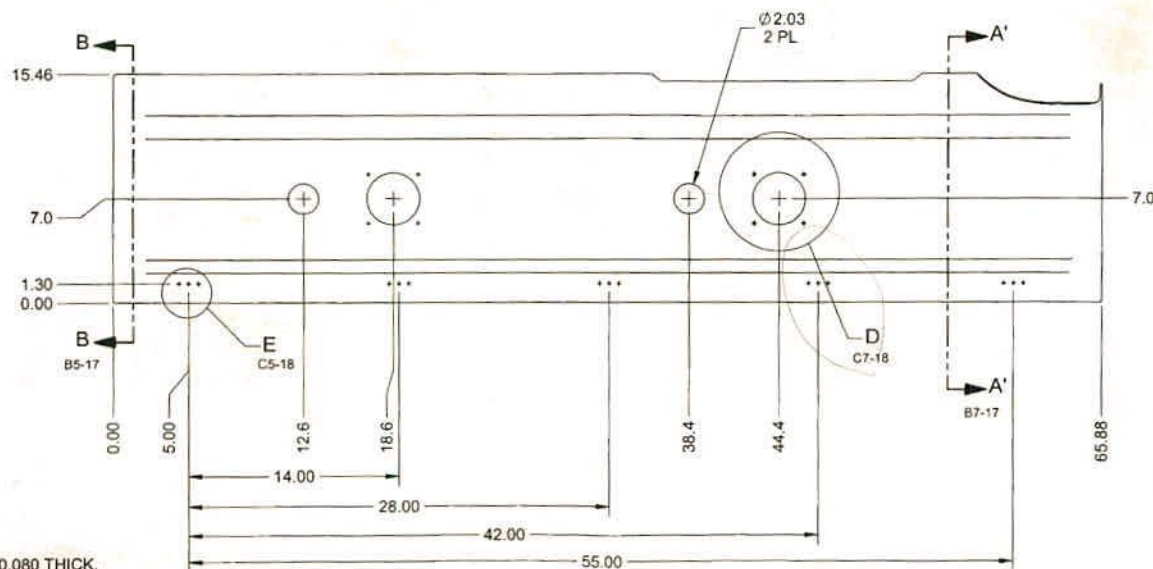
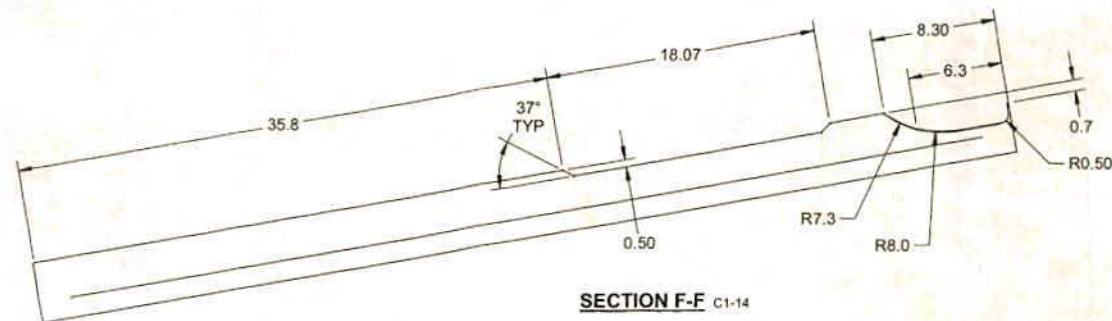
14.148377

1014.214

28.69.59

DL  
12/18/10





# NOTES:

1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 4.28 lbs

8) TEXTURE ON THIS SIDE

9) TRIM D4635-2 PER TOOL DT9840

10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL

MIN. THICKNESS AFTER FORMING:

SHADED AREA = 0.040

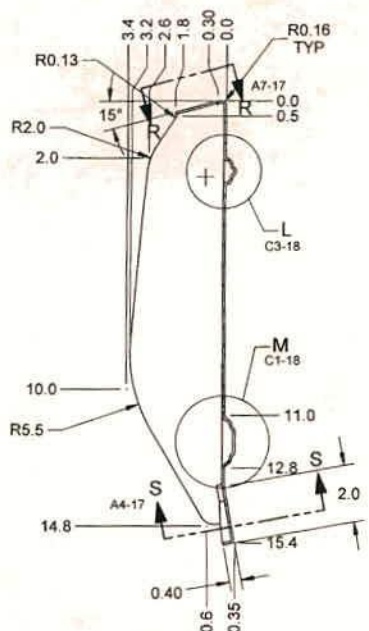
RIDGES/EDGES = 0.060

ELSEWHERE = 0.070

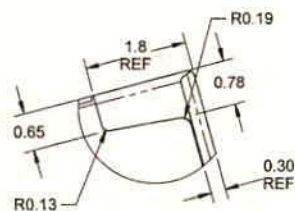
## D4635-2 RH, FWD CEILING PANEL

RELEASED  
2013-01-30

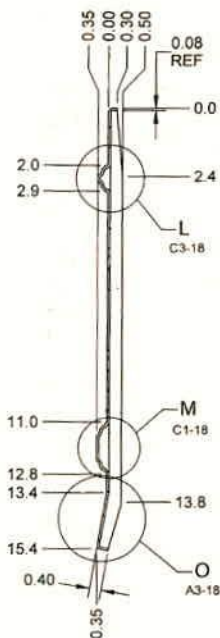
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4635	SHEET 14 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD CEILING PANELS	NTS
DATE	12.11.30	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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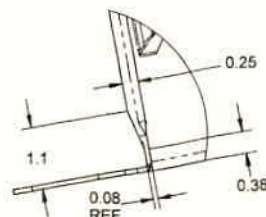
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SECTION A-A' OPPOSITE  
SCALE 2X



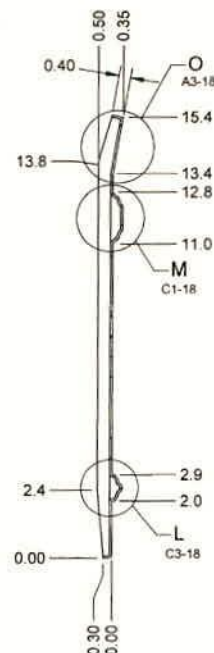
**AUXILIARY VIEW R-R**  
SECTION R-R' OPPOSITE  
SCALE 2X



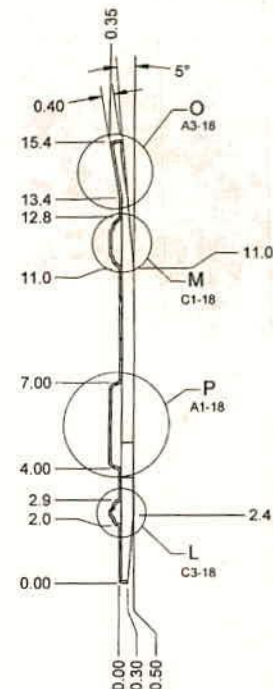
**SECTION B-B**  
SCALE 2X



**AUXILIARY VIEW S-S**  
SECTION S-S' OPPOSITE  
SCALE 2X



**SECTION G-G**  
SCALE 2X



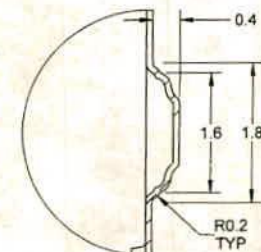
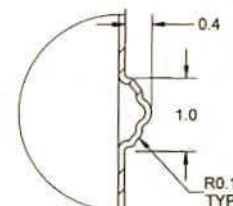
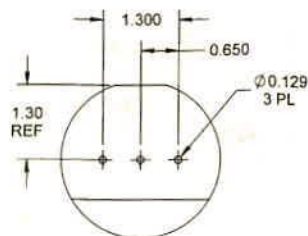
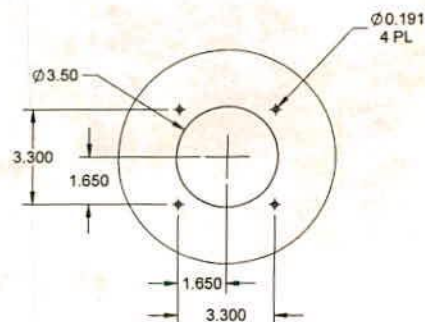
**SECTION K-K**  
SCALE 2X

RELEASED  
2013-01-30  
MP

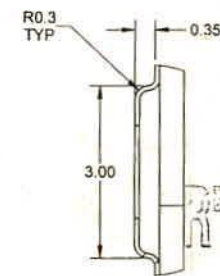
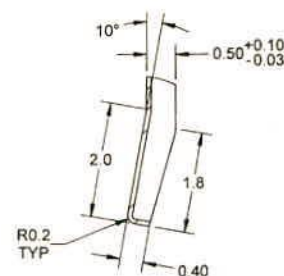
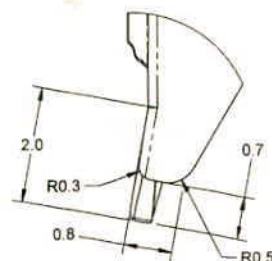
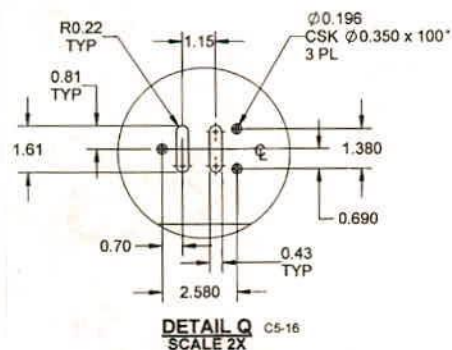
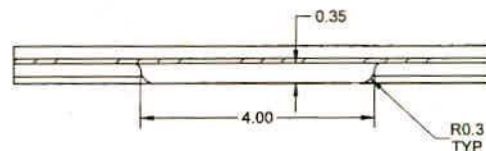
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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4635</b>	SHEET 17 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>OUTBOARD CEILING PANELS</b>	NTS
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8 7 6 5 4 3 2 1



DETAIL D  
SCALE 2X



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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order: 92956
Description: 139 RH TWD Ceiling Panel		Part Number: D4635-2.
Inspection Dwg: 4635	Rev: B	Page 1 of 1

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB	Date: 13/03/21
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**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
65.88	0.30	65.75	✓		TH 05	
15.46	0.30	15.44	✓		TH 05	
1.30	0.30	1.28	✓		TH 05 / TH 09	
5.00	0.30	5.00	✓		TH 05	
14.00	0.30	14.00	✓		TH 05	
28.00	0.30	28.00	✓		TH 05	
42.00	0.30	42.00	✓		TH 05	
55.00	0.30	65.00	✓		TH 05	
7.00	0.30	7.00	✓		TH 05	
12.6	1.00	12.625	✓		TH 05	
18.6	1.00	18.625	✓		TH 05	
38.4	1.00	38.4	✓		TH 05	

Measured by: BB	Date: 13/03/21
Audited by: E 13/04/05	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

*AD 10-04-14*



DART AEROSPACE LTD		Work Order:	92956
Description: D139 RH FWD CEILING PANEL		Part Number:	D4635-2
Inspection Dwg: 4635	Rev: 3	Page 1 of 1	

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>DT</i>	Date: 12/12/04
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**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
44.4	.100	44.4	✓		TH 05	
2.03	.030	2.01	✓		DL 02	
3.50	.030	<del>2.008</del> 3.51	✓		DL 02	
2.03	.030	2.008	✓		DL 02	
3.50	.030	3.51	✓		DL 02	
1.91	.030	1.93	✓		DL 02	
.50	.030	.526	✓		DL 02	
.40	.030	.41	✓		DL 02	
.30	.030	.33	✓		DL 02	
2.4	.100	2.42	✓		<del>DL 02</del> TH-05	
13.8	.100	13.8	✓		TH 05	

Measured by: <i>BB</i>	Date: 13/03/21
Audited by: <i>8 13/04/05</i>	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

*AD 10 04.14*



DART AEROSPACE LTD		Work Order: 92956
Description: 139 R & FWD CEILING PANEL		Part Number: D4635-2
Inspection Dwg: 4635	Rev: B	Page 1 of 1

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>DL</i>	Date: 12/12/04
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**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.8	.100	1.46			DL 02	SEE LETTER
.78	.030	.785	✓		DL 02	
.65	.030	.648	✓		DL 02	
.040	Min	.053	✓		DL 02	
.060	Min	.055		✓	DL 02	
.070	Min	.073	✓		DL 02	

Measured by: <i>BB</i>	Date: 13.03/21
Audited by: <i>8.13/4/05</i>	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

*AD 10.11.14*



## Daryl Leger

---

**From:** Roberto Fuentes  
**Sent:** Thursday, April 04, 2013 9:53 AM  
**To:** Daryl Leger; Harvey Siemens; David Shepherd; Mike Petsche; Eric Downing; Patrick Smith; Linda Lacelle  
**Subject:** Deviations for A139 drawings panels

Hi Daryl,

All this changing will be recorded as deviation for this first production and change the drawing after we get the comments from ERA from the first installation.

In response to your e-mail I summarize the following:

- 1) It is acceptable to change 1.8" to 1.4" dimensions for D4635-1/-2 Rev. B showing in Section A-A and Auxiliary View R-R.
- 2) It is acceptable change overall length of D4635-1/-2 from 65.88" to 65.75".
- 3) It is acceptable to have flange height on back side for D4635-1/-2/-3/-4 change from 0.40" to 0.35".
- 4) It is acceptable to have on D4635-1/-2/-3/-4 minimum thickness after thermo forming:  
Ridges/edges = 0.050"  
Elsewhere = 0.060"
- 5) This is applicable to note 8) of D4634 & D4635 drawings. Apply a bead (0.20" to 0.30 wide) of Devcon plastic welder II (0.25 inside of both edges of part) to bond ..... Wait for 2 to 4 hours for functional cure.
- 6) It is acceptable to identify with p/n & batch # at note 6) for D4634-141/-143/-145 & D4635-141/-142/-143/-144
- 7) This is applicable to note 10) of D4634-141/-143/-145. Locate D4647-3 angle using groove to align with ..... (Refer to Detail 'S')
- 8) This is applicable to note 11) of D4634-141/-143/-145. Transfer  $\varnothing 0.206$ " holes from D4634-# panel to D4694-# channels.

Roberto